

Date: Thursday, 05/06/2008 8:49:24 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE			
Job Number	: 39715		Part Number	: D37931			
Estimate Number	: 13310		Drawing Number	: D3793 REVA			
P.O. Number	:		Project Number	: N/A			
This Issue	: 05/06/2008 S.O. No. :		Drawing Revision	: A			
Prsht Rev.	: NC		Material	:			
First Issue	: / /		Due Date	: 12/06/2008 Qty: 30 Um: Each			
Previous Run	: 39419		10/d				
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet Comment: Qty.: 0.6197 sf(s)/Unit Total : 18.5913 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 108156 LB 8-6-9
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3793 Dwg Rev: A LB 8-6-9 Prog Rev: A (32)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE LB 8-6-9 (32)
4.0	QC8	SECOND CHECK Comment: SECOND CHECK S 08/06/09 (32)
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE 1-Deburr if necessary SB 08/06/11 (32)
2-Form on Brake as per Dwg D3793 using Jigs		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 8:49:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39715

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0 QC5

INSPECT WORK TO CURRENT STEP



8/5/08/06/12 (32)

counted

8/08/06/12 x32

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M105642



32X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: 12:00 a.m

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:30 p.m

mf 08/06/12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/08/06/12 (32)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



8/08/06/12 (32)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

fp 08/06/12

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/03/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-12

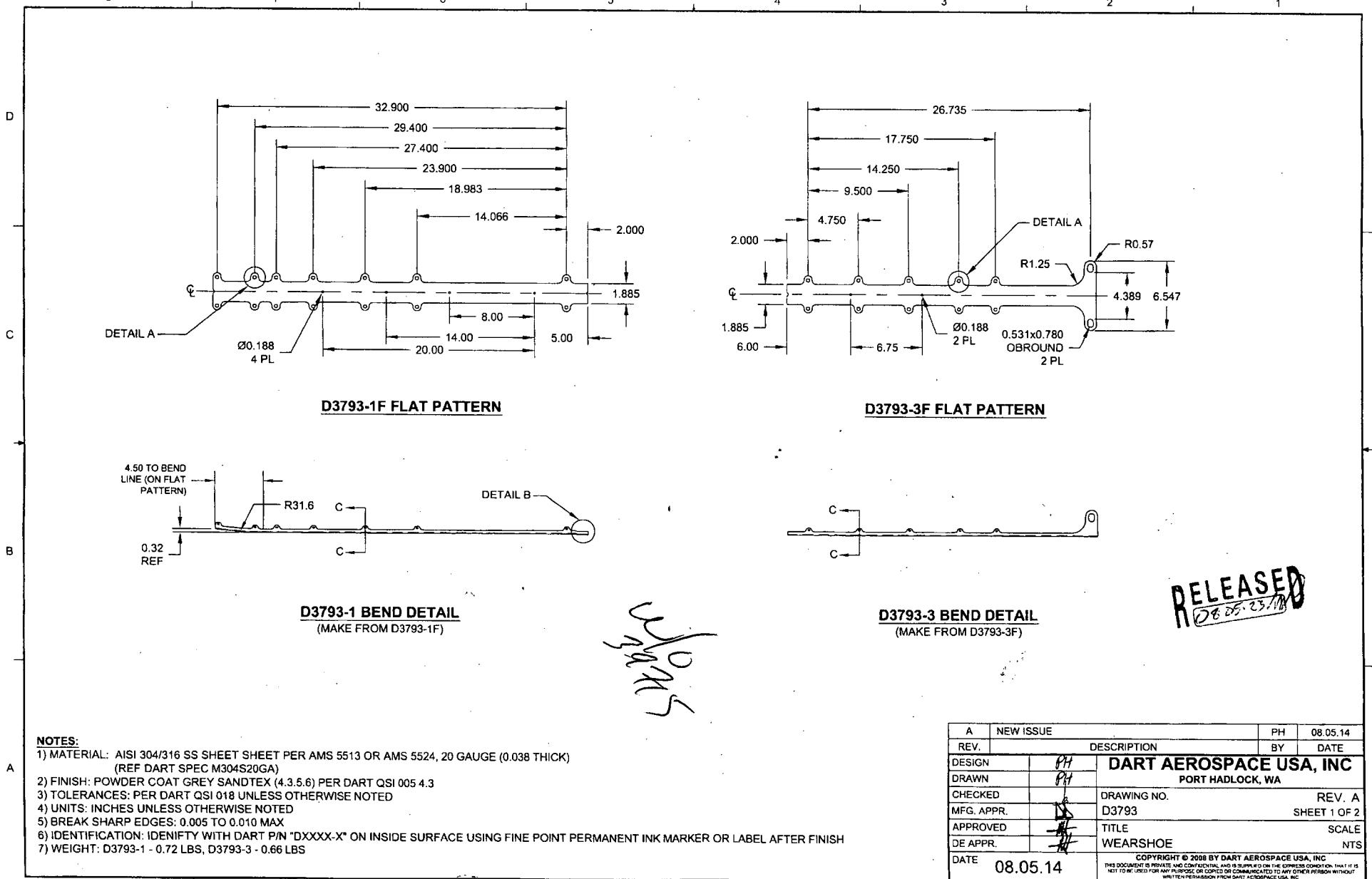
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

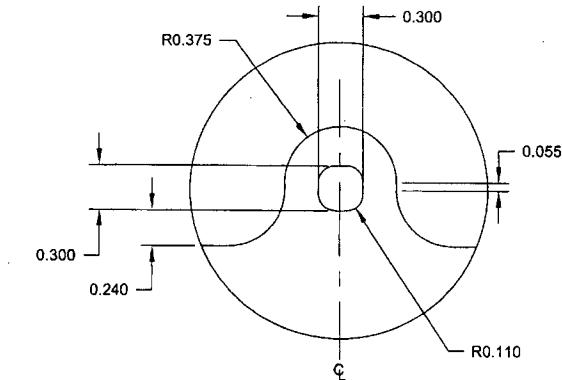
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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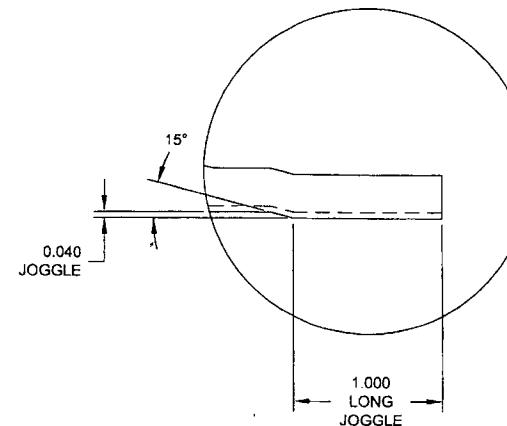
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

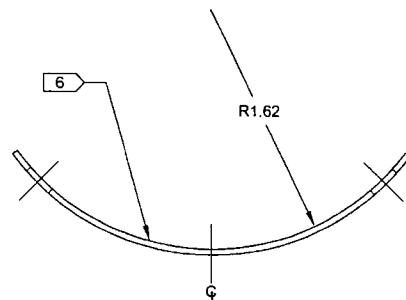
D



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

8 7 6 5 4 3 2 1

100%

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	PH	PORT HADLOCK, WA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3793
DE APPR.		SHEET 2 OF 2
		TITLE
		WEARSHOE
DATE	08.05.14	SCALE
		NTS

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RELEASED
08-05-23 MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39715
Description: WEAR SHOE	Part Number:	D3793-1
Inspection Dwg: D3793-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u> </u>	Prototype Approval: <u> </u>
Date: <u>8-6-09</u>	Date: <u>08/06/09</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	